

# Work Order ID 80068

\*80068\*

Page 1

Thursday, February 09, 2012 12:47:59 PM

Item ID: D4324-7

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Tube

Stop

\*NS2\*

Start Date: 2/10/2012 Start Qty: 3.00

\*3\*

Cust Item ID:

Required Date: 2/24/2012 Req'd Qty: 3.00

\*3\*

Customer:

Reference:

Approvals:

Process Plan: MF

Date: 2-02-09 Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4324

A

100

0.00

\*100\*

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut to length as per dwg

12/02/13

3

120

Manufacture as per dwg

0.00

\*120\*

Mill Conv

Memo

0.00

Conventional Milling Machine

12/02/13

3

130

QC6- Inspect dimensions to drawing

0.00

\*130\*

QC

Memo

0.00

Quality Control

8/7/13

43

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 80068

Thursday, February 09, 2012 12:47:59 PM

\*80068\*

Page 2

Item ID: D4324-7

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Tube

Stop \*NS2\*

Start Date: 2/10/2012 Start Qty: 3.00 \*3\*

Cust Item ID:

Required Date: 2/24/2012 Req'd Qty: 3.00 \*3\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.  
Code Qty Qty Number Stamp

140

Identify as per dwg & Stock Location: WA

0.00

\*140\*

Packaging

Memo

0.00

Packaging

12/2/14 *[Signature]*

150

QC21- Final Inspection - Work Order Release

0.00

\*150\*

QC

Memo

0.00

Quality Control

*[Signature]* M.C.J. 12/02/14

M.C.J. 12/02/2014  
(3)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, February 09, 2012 12:47:59 PM

Page 1

Work Order ID: 80068

Parent Item: D4324-7

Parent Item Name: Tube

Start Date: 2/10/2012

Required Date: 2/24/2012

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A 11.04.04 new issue DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased	No			100	f	137.1925	0.625	1.9736842			
304 RD Tube .750 x .049W													

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT017	137.19253	
109314	9.333	
111619	3	
112187	4	
112800	11	
114852	2.75	
116108	3	
117797	0.75	
118390	0.59363	
119160	2.7659	
120441	100	

2 ~~10~~ 12/02/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

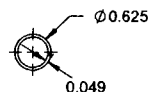
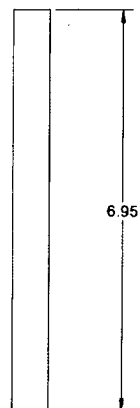
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

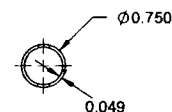
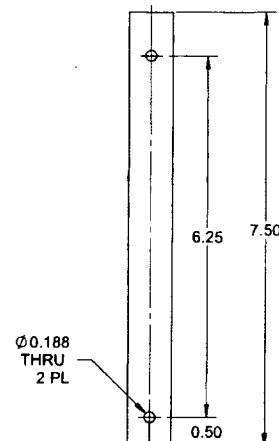
**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1



**D4324-5 TUBE**  
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-16)

# 80668



**D4324-7 TUBE**  
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-16)

RELEASED  
2011-04-08

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND TUBING  
PER ASTM A213 OR ASME SA213 OR ASTM A269  
REF DART SPEC. M304TR0.625W.049 & M304TR0.75W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.18 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D4324</b>	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 5 OF 5	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>VRD PARTS</b>	NTS
DATE	11.01.31	COPYRIGHT © 2011 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



Work Order: 89008

Part Number: 4324-7


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Inspection Dwg: 4324, Rev: A

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	X	Prototype
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Drawing	Dimension	Tolerance	Actual	Accept	Reject	Method of Inspection	Comments
7.50	±.030	7.503	—	CNC 02	Yes		
1.50	±.030	1.502	—	RA26	Yes		
6.25	±.030	6.254	—	CNC 02	Yes		
Ø.188	±.005	Ø.189	—	RA26			

Measured by:		Date:	12/02/13
Audited by:	S	Date:	12/02/13
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A			KJULM	